

Date: Thursday, 5/3/2007 11:39:22 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : UPPER AND LOWER PLATE
Job Number : 32206	
Estimate Number : 12838	
P.O. Number : <i>N/A</i>	Part Number : D3524041
This Issue : 5/3/2007 S.O. No. : <i>N/A</i>	Drawing Number : UNDER REVIEW <i>CB</i>
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i>	Drawing Revision : <i>N/A</i>
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/28/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 3 Um: Each
Comment : Est Rev: A New Issue 07-04-18 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X02000	6061-T6 Bar .25" X 2.0"
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Comment: Qty.: 0.2100 f(s)/Unit Total : 0.6300 f(s)
 6061-T6 Bar .25" X 2.0"
 batch: *M18398*

MS 07/05/11 3

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

9ml / J.L. / MS 07/05/11 3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9ml 07/05/24 3

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JA 07-05-24

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

5ml / BR 07/05/24 (3)

6.0	MS21075L06	ANCHOR NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

ANCHOR NUT

batch: *M101809-*

MF 07-05-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 11/05/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 32206

Part Number: D3524041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 24.0000 Each(s)

RIVET

batch: m102404 -

mf 07-05-25

(3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/05/28

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/28 (3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion



U 07-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

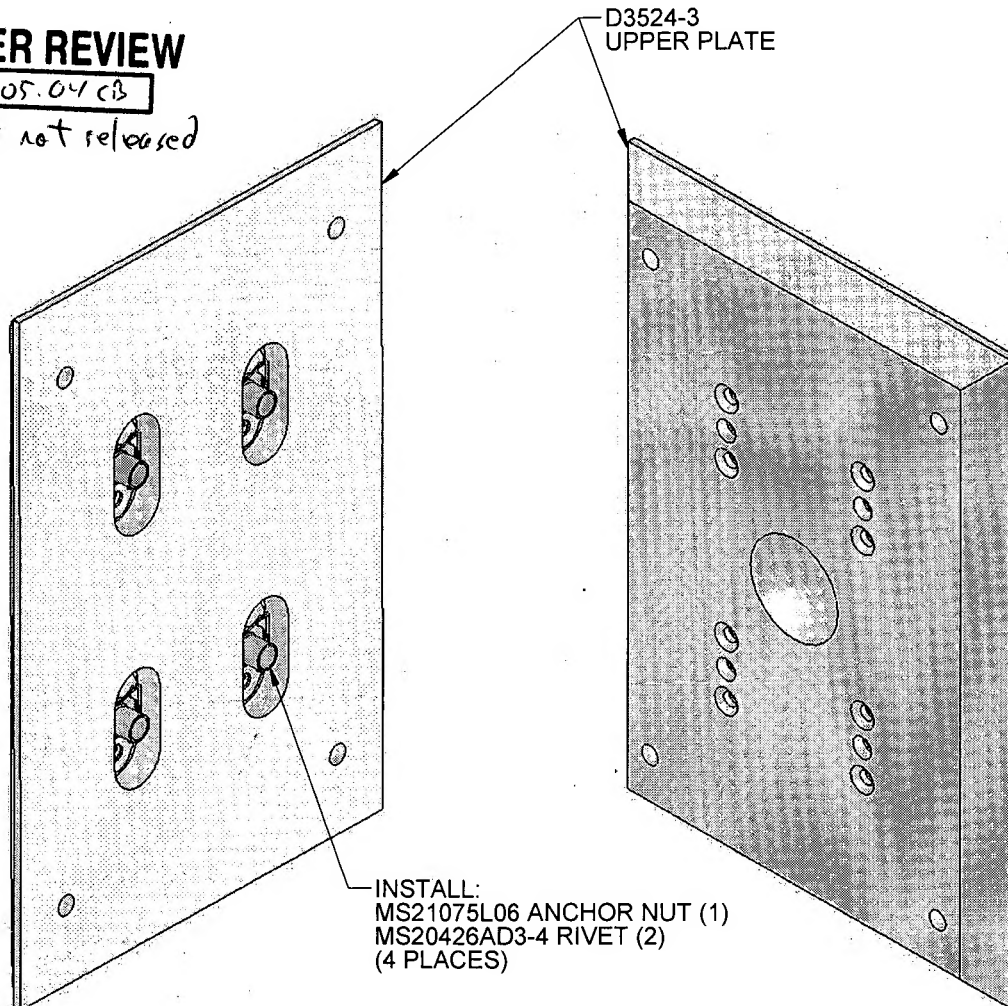
NOTE: Date & initial all entries

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.01.10		TITLE UPPER AND LOWER PLATE	SCALE 1:1

UNDER REVIEW

07.05.04 CB

img not released



D3524-041 UPPER PLATE ASSEMBLY

PARTS LIST:

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

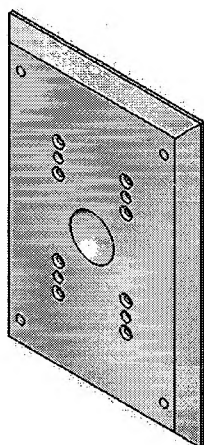
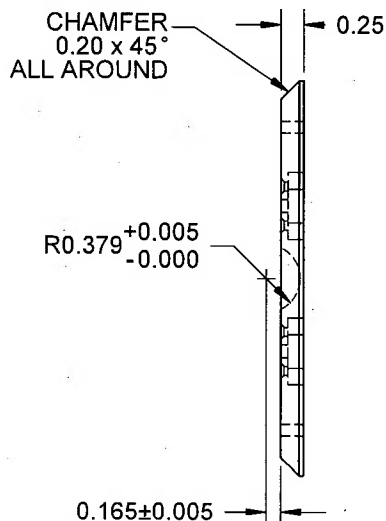
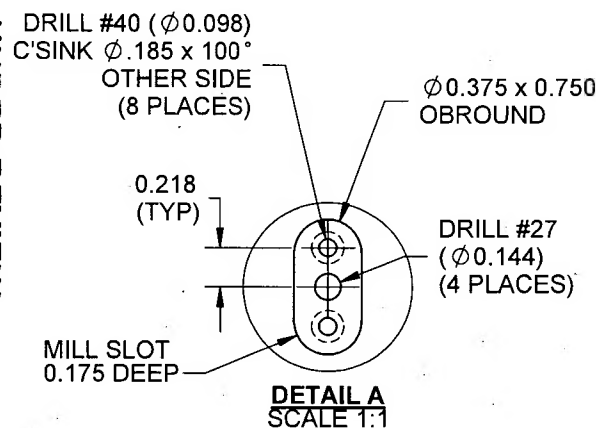
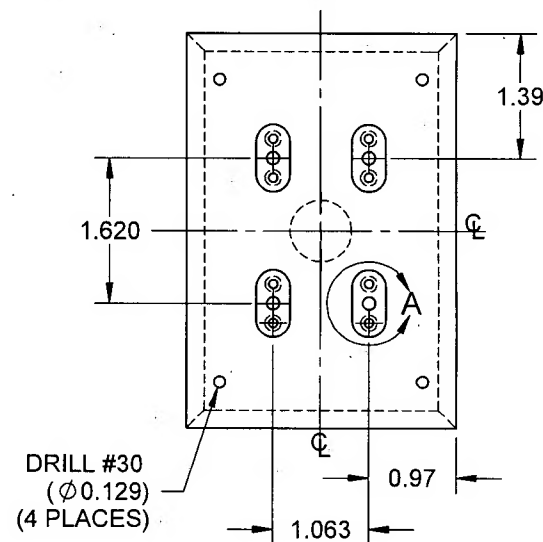
NO. **32206**

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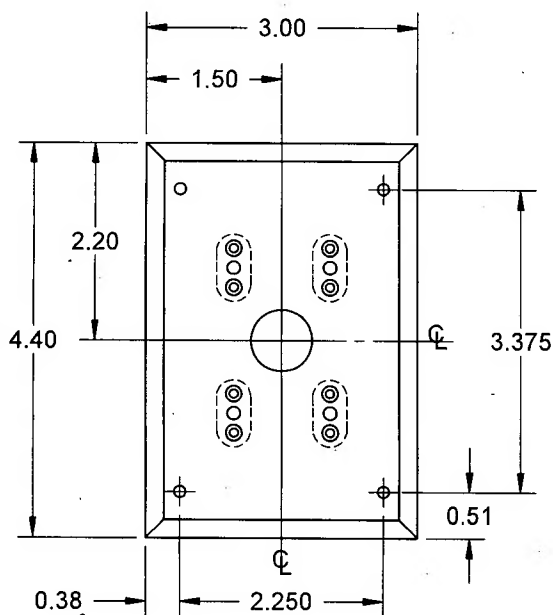
REVISION 15 JUL 2010

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD
CHECKED	P.H.	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.01.10	TITLE	D3524	REV. A
		UPPER AND LOWER PLATE		SHEET 3 OF 3
		SCALE	1:2	



UNDER REVIEW

07.05.01 C.B.



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WITHOUT NOTICE
WORK ORDER
NO. 32606
D3524-3 UPPER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT C

Ed

DART AEROSPACE LTD		Work Order:	32206
Description: UPPER PLATE		Part Number:	D3524-3
Inspection Dwg: D3524 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	$\pm .030$	2.998	—			
1.50	$\pm .036$	1.499	—			
2.20	$\pm .036$	2.199	—			
4.40	$\pm .036$	4.398	—			
0.38	$\pm .030$	0.375	—			
2.250	$\pm .005$	2.252	—			
0.57	$\pm .036$	0.570	—			
3.375	$\pm .005$	3.375	—			
0.25	$\pm .036$	0.253	—			
0.20X45°	$\pm .030$	0.200X45°	—			
R0.379	$\pm .005$	R0.380	—			
1.620	$\pm .005$	1.619	—			
Ø0.129	$\pm .004$	Ø0.129	—			
1.063	$\pm .005$	1.063	—			
0.97	$\pm .036$	0.969	—			
1.39	$\pm .036$	1.387	—			
Ø0.375X.750	$\pm .010$	Ø0.375X.749	—			
Ø0.144	$\pm .004$	Ø0.144	—			
0.175	$\pm .010$	0.172	—			
0.218	$\pm .005$	0.218	—			
Ø.185X100°	$\pm .010$	Ø0.181X100°	—			
Ø0.098	$\pm .004$	Ø0.098	—			

Measured by: <i>gmk</i>	Audited by: <i>SD</i>	Prototype Approval: <i>CB</i>
Date: 07/05/24	Date: 07/05/24	Date: 07/05/24

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	